• Work Order ID 61096

HAAS CNC vertical machine #1



August 6, 2010 8:4	6:15 AM	•			•	,				rage
Item ID: D4	102-3		Accept					etup Start		
Revision ID:				1 100)((at 616 181)1 99((68()		et tiali seii	1611 1561 ~	т.,		
Item Name: SHI	M							Stop		
Start Date: 06/	08/2010 Start Qty: 1.00			Cust Item I	D:					
Required Date: 10/	08/2010 Req'd Qty: 1.00			Customer:		POSITIVE)			
Reference:	10.0b. de		· ·	• .						
Approvals: Pr	ocess Plan:	Date:	¹ Tooling:	Da	ıte:		F	Run Start		
Q	C:	Date:	SPC (Y/N):	Da	ıte:			Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr	1				•				
D4102	REV. PRELIM PB2	- AM				-			r	
100	Cut blanks as per folio		0.00	7						
	•		82	10/08/08			. /	8	•	
Bandsaw	Memo		0.00	1909						·
Jeaspa Bandsaw	4.950" long		. «							!
							•	•		•
							•			
110			0.00					, .		
		•		¥ ·						
HAAS 1	Memo	•	0.00	· · · · · · · · · · · · · · · · · · ·						• •

MILL AS PER DWG AND FOLIO FA945 FOLIO REV: A4 DWG REV: P63

DEBURR

Work Order ID 61096



Page 2

August 6, 2010 8:46:15 AM

Item ID:

D4102-3

Revision ID:

SHIM Item Name:

Start Date:

06/08/2010

Required Date: 10/08/2010

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

QC:

Date: Date: · Tooling:

Accept

SPC (Y/N):

Toot ID

Date:

Date:

Tool # Plan

Reject Qty-

Setup Start

Run Start

Stop.

Insp. Stamp

Work Center ID

120

Sequence ID/

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ Run Hours

0.00

Accept Qty Code

Reject Number

130



Quality Control

QC8- Inspect parts second check

Memo

Memo

Dy only Sioloslio (1)

0.00 - inspate 10 PBZ

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Work Order ID 61096



Page 3

August 6, 2010	8:46:15 AM									
Item ID: Revision ID:	D4102-3	i		Accept			s s	etup Sta	rt	
Item Name:	SHIM							Sto	р	
Start Date: Required Date: Reference:	06/08/2010 10/08/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D;				
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ıte:	, R	tun Sta	i (188 1), e i (
-	QĆ:		Date:	SPC (Y/N):	Da	nte:	-	Sto	p	
Sequence ID/ Work Center II 150	D	Operation Description QC3- Inspect Part Finish		Set Up/ Run Hours 0.00	Tool ID	Tool # Plan Code		Reject Qty	Reject Number	Insp. Stamp
QC Quality Control		. Memo		0.00		LD. SIL	())— <u> </u>			
160		Identify as per dwg & Stock	C Location:	0.00			[.(16/w		
Packaging Packaging		Memo	DAVI'd Shep	sher			_/0			
170		QC21- Final Inspection - W	Vork Order Release	0.00						
QC Quality Control		Memo		0.00		EFF	SITIVE RI)816_A	UTH <u>~</u>	 NF 10-8-

August 6, 2010 8:46:15 AM

Work Order ID: 61096

Parent Item:

D4102-3

Parent Item Name: SHIM



Start Date: 06/08/2010

Required Date: 10/08/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased	No				f	16.2347	0.042	0.044211			

6061-T6 Bar .250 x 4.00

Location Loc Qty MAT 16.234734 0.279156 110680 114608 15.955578 Loc Code

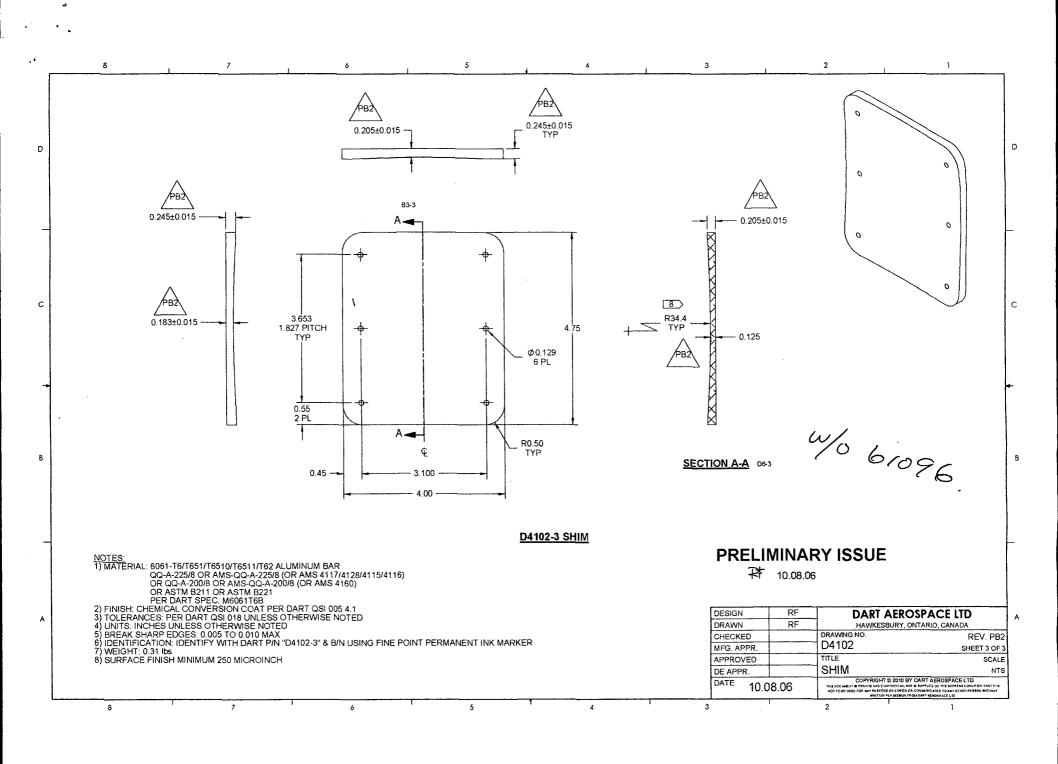
) + 0.2348 SCRAP

DART AEROSPACE LTD	Work Order:	61096
	Part Number:	04102 - 3
Inspection Dwg: 194102 Rev: PB2		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.55	1.030	.55	/		V 57/2	
4.00	7	4.015	/		. 1)	
4.75	1	4.75			1)	
.45	1/	759	V		11	
	1.010	3.654			10	
3.653	3) 54	3.100			l)	
3.100	1,	3.700				
167	4					
-239	+.015 +.00 F	129			11	
Ø.129					1	
, 205	±.015	.192			51 1	
. 245	±.015	127			11	
.783	2.01	.137		+		
			1	 	4	
		-	 		·	,
1			+	 		
				 		
					-	
			 			
				-		
			 	-	_	
·						

Measured by:	Audited by: S	Preliminary Approval:	
Date: 10/08/09	Date: 10/05/10	Date:	
	inspecto to PBQ cay	 Revised by	Approved
Rev Date Change	ry approval	 KJ	



Kim Johnston

From:

David Shepherd [dshepherd@dartaero.com]

Sent:

Thursday, August 12, 2010 12:24 PM

Sent:

'Kim Johnston'

Subject:

RE: three more prelim work orders

Kim,

Yes ... These parts will also be scrapped after testing.

David

----Original Message----

From: Kim Johnston [mailto:kjohnston@dartaero.com]

Sent: Thursday, August 12, 2010 5:48 AM

To: David Shepherd

Subject: three more prelim work orders

Hi David,

I have three more prelim work orders, D4102-1 B61093, D4102-2 B61095 and

D4102-3 B61096. Have they also been sent to you for testing? Can you confirm this for me by email and let me know if they will be scrapped after.

I'll attach your email to the work orders and file them. Thanks,

Kim Johnston
Dart Aerospace Ltd.
Engineering Clerk
Document Control
1270 Aberdeen Street
Hawkesbury, Ontario, K6A 1K7
Email: kjohnston@dartaero.com

Tel: 613-632-5200 Fax: 613-632-9311

No virus found in this incoming message.

Checked by AVG - www.avg.com

Version: 8.5.441 / Virus Database: 271.1.1/3066 - Release Date: 08/12/10 06:34:00